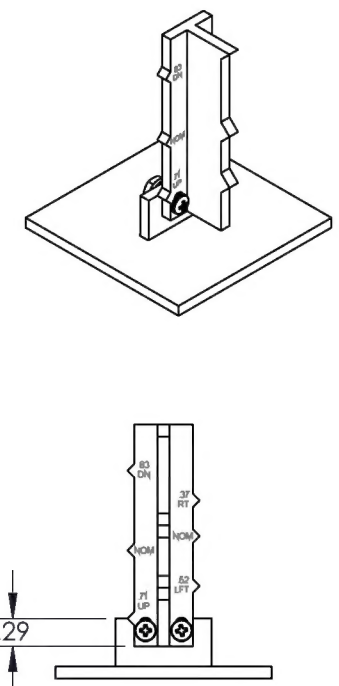
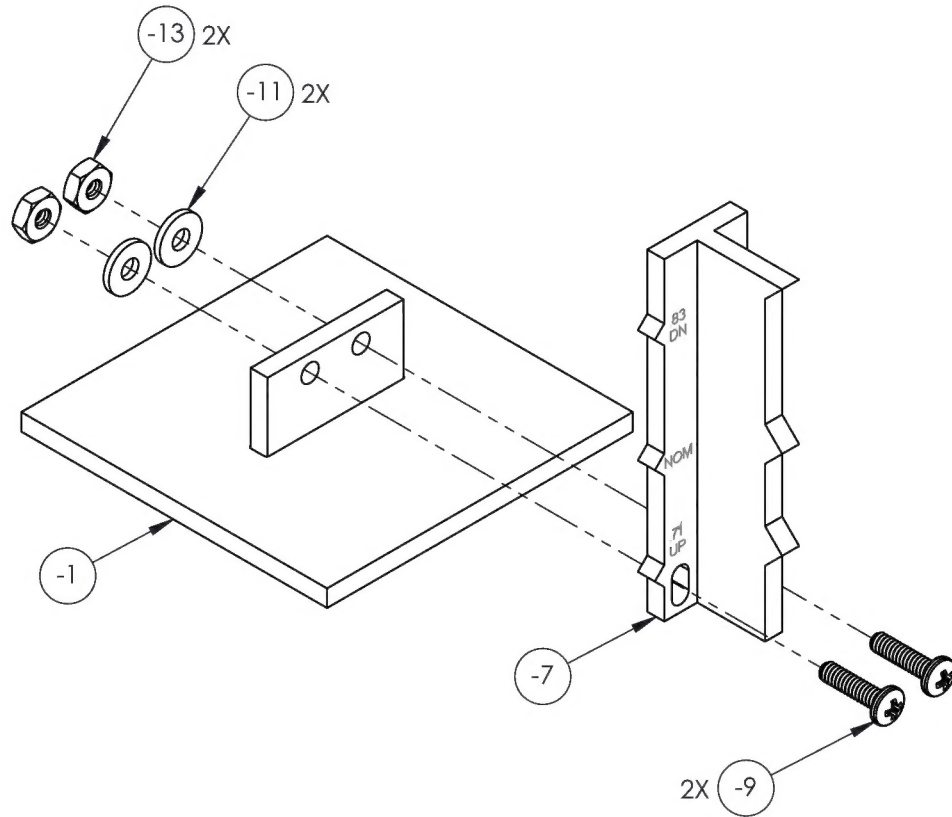


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	4/7/2017	RJC	JAG



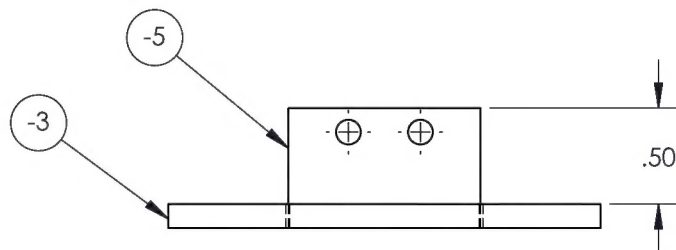
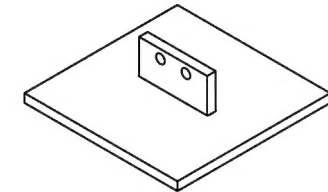
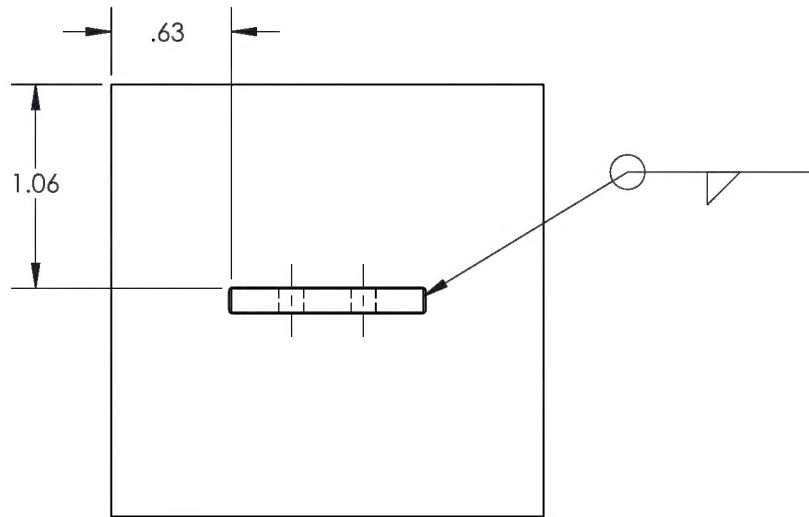
NOTE:
OEM REF. ITEM ST502.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	BASE WELDMENT			2
	1		-3		BASE	6061		3
	1		-5		PLATE	6061		4
			-7	1	GAUGE	6061		5
		B/O	-9	2	ROUNDED HEAD SCREW	STEEL	#4-40 X 7/16 (MCMaster-CARR #90272A109)	1
		B/O	-11	2	FLAT WASHER	STEEL	#4 (MCMaster-CARR # 90126A505)	1
		B/O	-13	2	HEX NUT	STEEL	#4-40 UNC (MCMaster-CARR #90480A005)	1
	ASSY -1							

DART AEROSPACE	
TITLE COLLECTIVE RIGGING FIXTURE (RH COMMAND)	
DWG NO. RBT18619	REV 1
MAT'L TREAT FINISH SPEC	
DRAWN BY: CLOUGH CHECKED: DD 04/05/2017 OPPTS APPR: AA 04/05/2017 QA APPR: JL 04/05/2017 APPROVED: JAG 07/11/2017	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL MD 369D/E/FF - 500N	
SCALE 1:1	DATE 4/3/2017
SHEET 1 OF 5	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



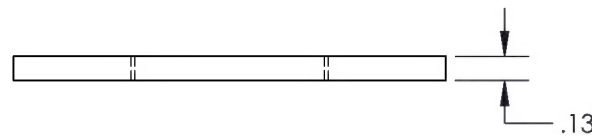
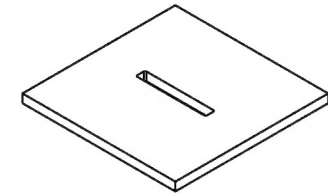
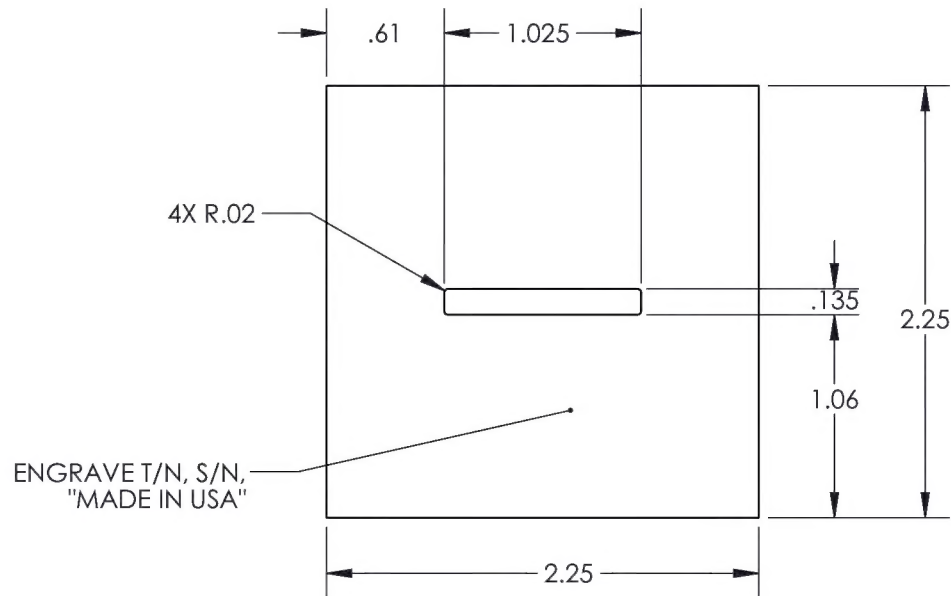
(-1)

BASE WELDMENT

DART AEROSPACE	
TITLE COLLECTIVE RIGGING FIXTURE (RH COMMAND)	
DWG NO. RBT18619-1	REV 1
MAT'L HEAT TREAT FINISH CLEAR ANODIZE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/
SPEC MIL-A-8625F, TYPE II, CLASS I	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DD 04/05/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 04/05/2017	
QA APPR: JL 04/05/2017	USED ON MODEL
APPROVED: JAG 07/11/2017	MD 369D/E/FF -500N
SCALE 1:1	DATE 4/3/2017
SHEET 2 OF 5	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



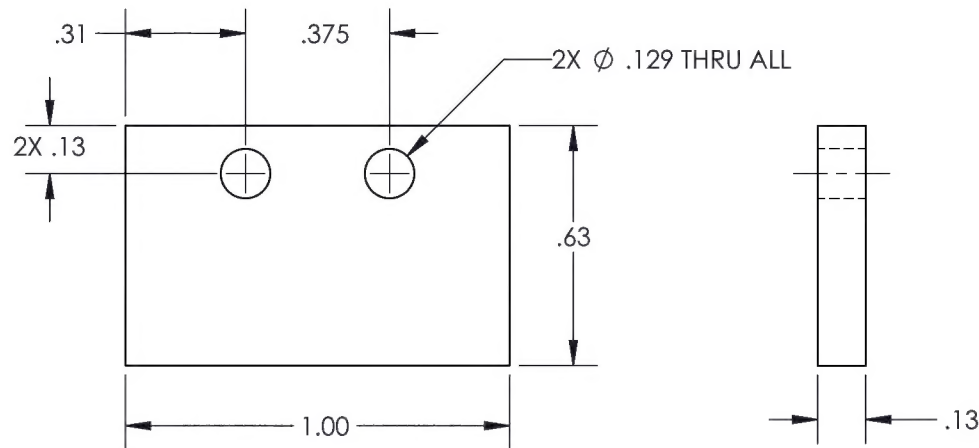
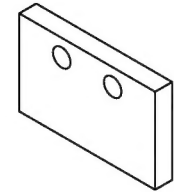
③

BASE

DART AEROSPACE	
TITLE COLLECTIVE RIGGING FIXTURE (RH COMMAND)	
DWG NO.	RBT18619-3
REV 1	
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DD 04/05/2017	.015 x 45° OR .015R
OPPS APPR: AA 04/05/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 04/05/2017	AFTER PLATING
APPROVED: JAG 07/11/2017	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 4/3/2017
	SHEET 3 OF 5

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



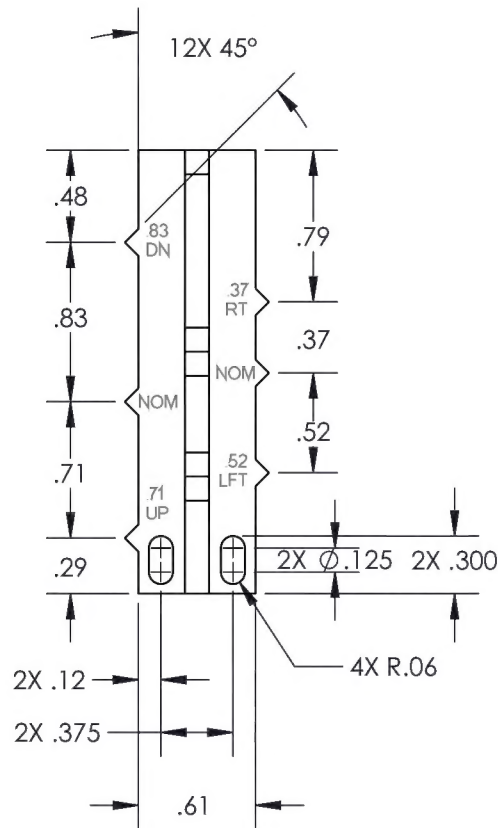
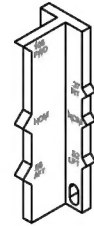
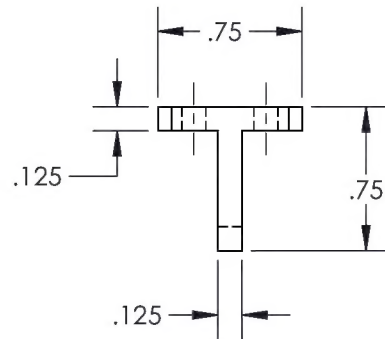
(-5)

PLATE

DART AEROSPACE	
TITLE COLLECTIVE RIGGING FIXTURE (RH COMMAND)	
DWG NO. RBT18619-5	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC	.XX \pm .01 ANGLES \pm .5°
	.X \pm .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DD 04/05/2017	.015 x 45° OR .015R
OPPS APPR: AA 04/05/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 04/05/2017	AFTER PLATING
APPROVED: JAG 07/11/2017	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 2:1	DATE 4/3/2017
	SHEET 4 OF 5

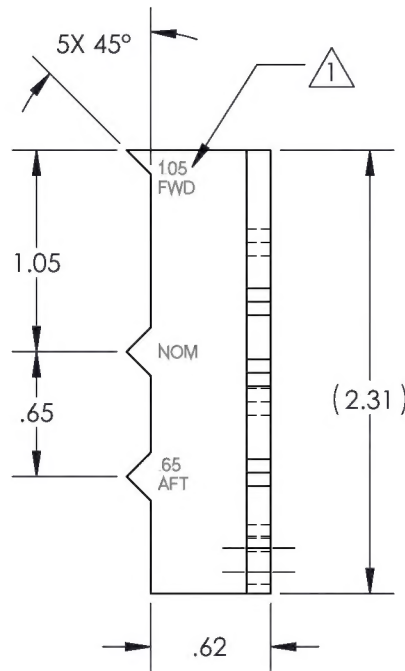
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REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED



(-7)

GUAGE



NOTE:
MACHINE ENGRAVE ALL TEXT, FILL IN WITH WHITE PAINT.

DART AEROSPACE	
TITLE COLLECTIVE RIGGING FIXTURE (RH COMMAND)	
DWG NO. RBT18619-7	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH RED ANODIZE	.XXX ± .005 FRACTIONS ± 1/8
SPEC MIL-A-8625F, TYPE II, CLASS III	.XX ± .01 ANGLES ± 5°
DRAWN BY: CLOUGH	.X ± .1 SURFACES = 125
CHECKED: DD 04/05/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 04/05/2017	.015 x 45° OR .015R
QA APPR: JL 04/05/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED: JAG 07/11/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	DATE 4/3/2017
	SHEET 5 OF 5